

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave.St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-026907**Date Inspected:** 08-Aug-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Shigang/Jun**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Bike Path**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Scott Leavitt, was present during the times noted above for observations relative to the work being performed.

Bay 9

Heat Straightening

This QA Inspector observed the following work in progress: ZPMC personnel heat straightening Bike Path Travel Rail member identified as 3018TR1-001. Distortion appeared to be caused by welding. ZPMC Quality Control (QC) inspector identified as Chen Shigang was present to monitor the heat straightening process. The heat straightening appeared to comply with Heat Straightening Report (HSR) Number (B)-10415

Visual Inspection

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No 09931.

This QA inspector performed VT of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel.

The members are identified as:  
3010TR1-001-001, 002, 003, 004, 005, 008, 009, 012, 013, 014, 015, 016

---

## WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

---

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No 09932.

This QA inspector performed VT of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel.

The members are identified as:

BK9003A3-001-065, 066, 084, 085, 103, 014, 122, 123, 077, 078, 096, 097, 115, 116, 134, 135

BK9003A5-001-052, 053, 054, 055, 056, 057, 058, 059, 060, 061, 062, 063

BK9003A6-001-035, 036, 037, 038, 039, 040, 042, 043

BK9003A11-001-019, 020, 021, 022, 023, 024, 025, 026, 027, 028, 029, 030, 031, 032, 033, 034, 035, 036, 037, 038

### Magnetic Particle Inspection (MT)

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No 09932.

This QA inspector performed MT of approximately 15% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated an MT report for this date.

The members are identified as:

BK9003A3-001-065, 066, 084, 085, 103, 014, 122, 123, 077, 078, 096, 097, 115, 116, 134, 135

BK9003A5-001-052, 053, 054, 055, 056, 057, 058, 059, 060, 061, 062, 063

BK9003A6-001-035, 036, 037, 038, 039, 040, 042, 043

BK9003A11-001-019, 020, 021, 022, 023, 024, 025, 026, 027, 028, 029, 030, 031, 032, 033, 034, 035, 036, 037, 038

### Ultrasonic Testing Inspection (UT)

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No 09931.

This QA inspector performed UT of approximately 10% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated a UT report for this date.

The members are identified as:

3010TR1-001-001, 002, 003, 004, 005, 008, 009, 012, 013, 014, 015, 016

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

### Summary of Conversations:

No relevant conversations.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or

---

## WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

---

remedial efforts please contact Eric Tsang at 15000422372, who represents the Office of Structural Materials for your project.

---

<b>Inspected By:</b>	Leavitt, Scott	Quality Assurance Inspector
<b>Reviewed By:</b>	Clifford, William	QA Reviewer

---